

Work Order ID 67812

Thursday, March 31, 2011 9:18:11 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4373-9

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cup

Start Date: 3/31/2011 Start Qty: 2.00



Cust Item ID:



Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Handwritten: 11-03-31

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4373	PA1

100

0.00



Lathe Conv

0.00

Conventional Lathe

Memo

TURN AS PER DWG
DWG REV: PA1

DEBURR

J.F.S. 11/03/31

1 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

J.F.S. 11/03/31

1 0

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

E 11.03.31

1 0

Work Order ID 67812

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Page 2

Item ID: D4373-9

Accept

Revision ID: PRELIM

Item Name: Cup

Start Date: 3/31/2011 Start Qty: 2.00

Required Date: 4/1/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

121

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 0 11-03-31

122

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BL 11-3-31

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

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Page 3

Item ID: D4373-9

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cup

Start Date: 3/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD 1310mar
RD 2370

ME
11-03-31

POSITIVE RECALL

EFFECTIVE 4/6/31 AUTH LC

RELEASED _____ DATE _____

Picklist Print

Page 1

Thursday, March 31, 2011 9:18:08 AM

Work Order ID: 67812



Parent Item: D4373-9



Parent Item Name: Cup

Start Date: 3/31/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 11-03-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500		Purchased			No		f	11.6700		0.136842			
6061 RD bar 3.50													

Location

Loc Qty

Loc Code

MAT005

6

116808

6

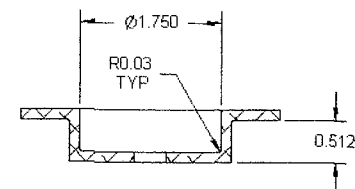
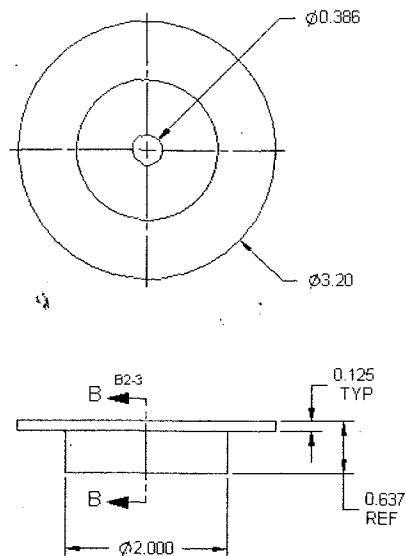
MAT036

5.67

110993

5.67

J.F.S. 11/03/31 0.136842



SECTION B-B CS-3

D4373-9 CUP

NOTES

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs

DESIGN	PC	DART AEROSPACE LTD	
DRAWN	BF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. PA1
MFG. APPR.		D4373	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR HARDWARE	NTS
DATE	11.03.29	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CONTAINS THE DART AEROSPACE LTD. PROPERTY RIGHTS NOT TO BE USED FOR ANY PURPOSE OR COPIES OF THIS DOCUMENT TO ANY OTHER PERSON OR GROUP WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

